

Work Order ID 74703 -2

Wednesday, October 05, 2011 11:37:01 AM

Page 1

Item ID: D3953-3

Revision ID:

Item Name: Gas Spring Stud, Lid

Start Date: 10/5/2011 Start Qty: 20.00

Required Date: 10/14/2011 Req'd Qty: 20.00

Reference:

Approvals:

Process Plan: M.L.J

Date: 11/10/05

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3953

C

0.00

0.00

0.00

0.00

100

Doosan

Doosan Lathe

Memo

Turn as per folio FA852 & DWG
FOLIO REV:
DWG REV:

DEBURR

QC2- Inspect parts off machine FAI/FAIB

Memo

110

QC

Quality Control

Accept

Setup Start

Stop

Run Start

Stop

Cust Item ID:

Customer:

SPLIT

ASAP

19

19

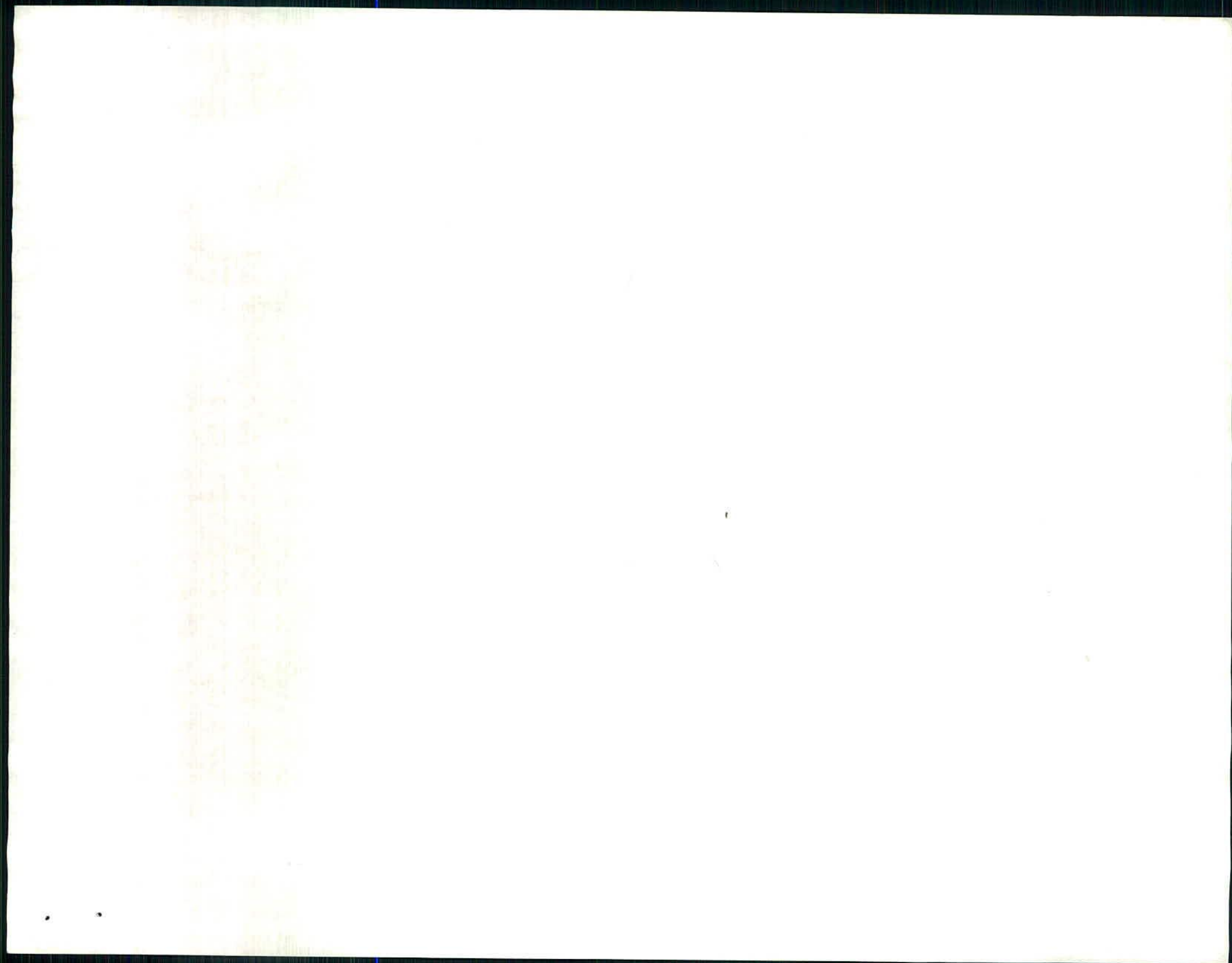
φ

19

φ

11/10/05

11/10/05



Work Order ID 74703

Wednesday, October 05, 2011 11:37:01 AM

Page 2

Item ID: D3953-3

Accept

Setup Start

Revision ID:

Stop

Item Name: Gas Spring Stud, Lid

Start Date: 10/5/2011 Start Qty: 20.00

Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 20.00

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

B.A 11/10/11

19

φ

QC

Memo

0.00

Quality Control

130

Identify as per dwg & Stock Location 096

0.00

Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

Signature (19)

11/10/12 *Signature*
ME
11-10-12



Picklist Print

Page 1

Wednesday, October 05, 2011 11:37:05 AM

Work Order ID: 74703



Parent Item: D3953-3



Parent Item Name: Gas Spring Stud, Lid

Start Date: 10/5/2011

Required Date: 10/14/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP RevA: New issue DD verified by:EC
per dwg revC DD 10.03.02 verified by:EC

IPP Rev:B as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304RO.750

Purchased

No

100

f

71.4730

0.125

2.631579



Handwritten signature/initials

304 SS Roundbar .750

Location

Loc Qty

Loc Code

MAT028

25.826

116501

1.746

116623

24.08

MAT029

45.647

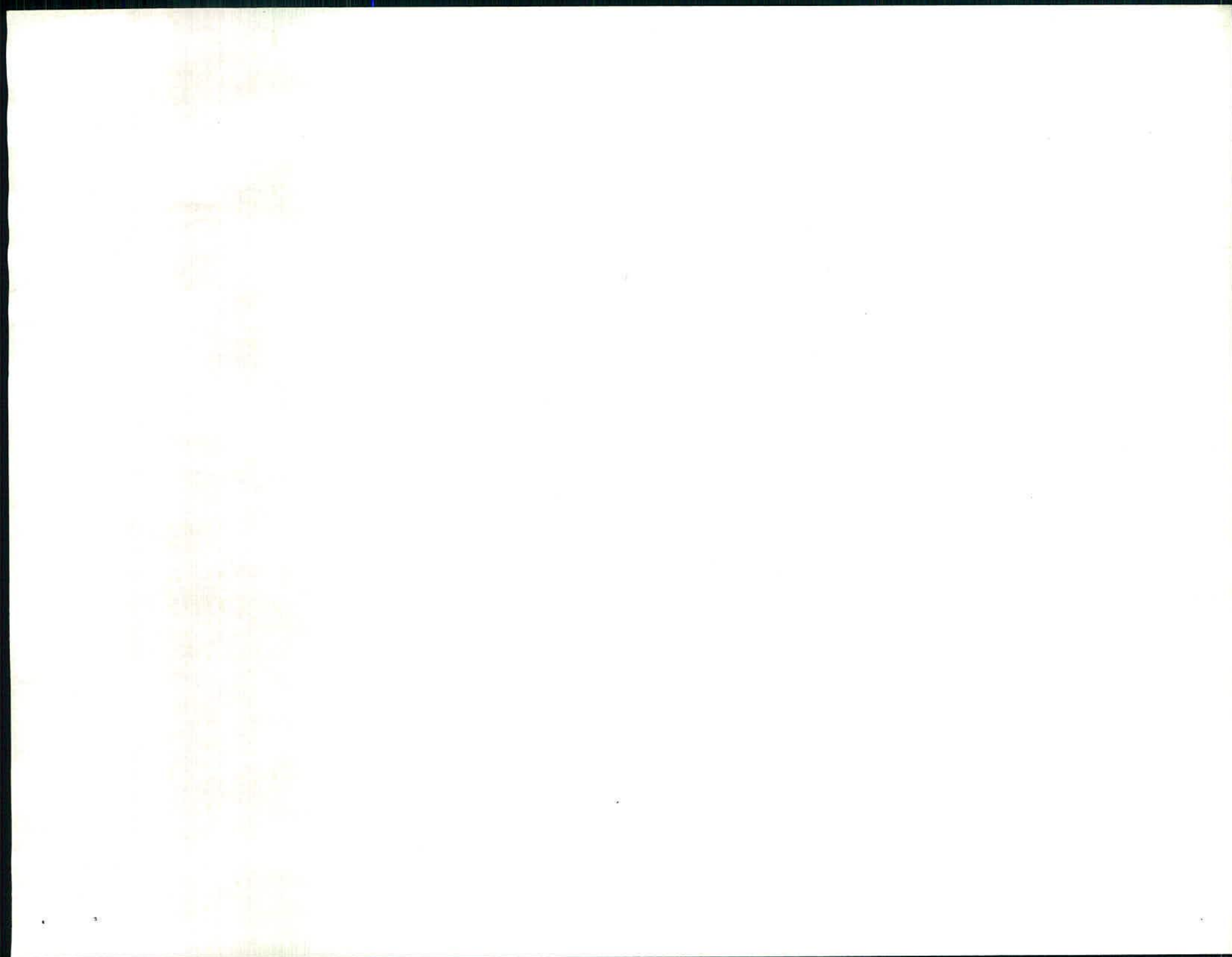
117481

21.447

118509

24.2

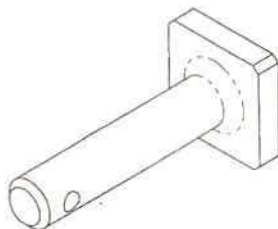
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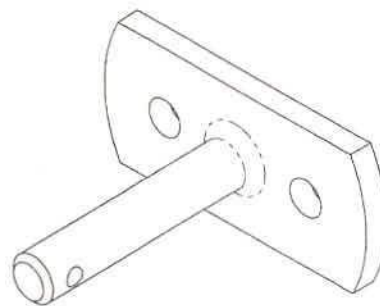




D3953-1 GAS SPRING BRACKET
(FULL LID)



D3953-3 GAS SPRING STUD, LID



D3953-5 GAS SPRING STUD, BASE



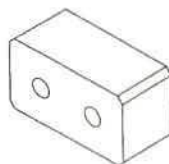
D3953-7 GAS SPRING SPACER



D3953-9 GAS SPRING WASHER



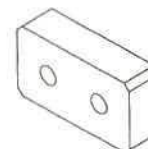
D3953-11 GAS SPRING SPACER



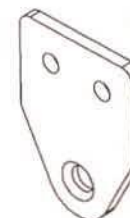
D3953-13 GAS SPRING SPACER
(FULL LID)



D3953-15 GAS SPRING BRACKET
(SPLIT LID)



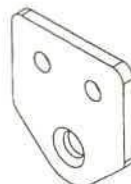
D3953-17 GAS SPRING SPACER
(SPLIT LID)



D3953-19 GAS SPRING BRACKET
(SQUARE BASKET)

RELEASED
2010-07-26

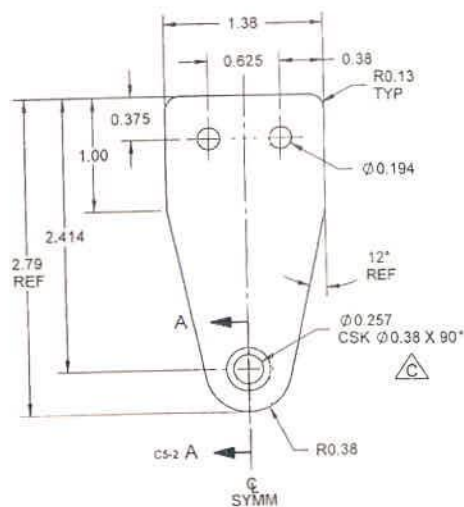
NOT COPY
RETURNED
ENGINEERING
UNCONTROLLED
SUBJECT TO APPROVAL
WITHOUT NOTICE
WORK ORDER
NO. 24203 M.L.O.
11/10/05



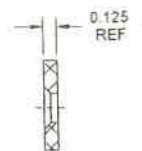
D3953-21 GAS SPRING BRACKET
(SQUARE BASKET)

C	PARTS -19 & -21 ADDED (SHT 18.4); CSK CALLOUT WAS CHAM (C5-2, B6-3, C6-4). & SYMM WAS & SYM ABOUT (C7-2, C7-4), SECTION C-C REPOSITIONED TO B2-4 REASON: ADDL PARTS REQD, DRAFTING ERRORS		JPH	10.01.29
	SHEET 3 ZONE C1 DIM 0.05 MIN WAS 0.13, MULTIPLE DIMENSIONS MIN/MAX REMOVED TOLERANCE ADDED. REASON: DIFFICULTY INSTALLING COTTER PIN AT NEXT ASSY		AJS	09.11.11
B	NEW ISSUE		AJS	09.07.27
REV		DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	JPH			
CHECKED	JPH	DRAWING NO.	REV. C	
MFG. APPR.	JPH	D3953	SHEET 1 OF 4	
APPROVED	JPH	TITLE	SCALE	
DE APPR.	JPH	GAS SPRING LID COMPONENTS	NTS	
DATE		10.01.29	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND IS AVAILABLE TO THE GENERAL PUBLIC WITHOUT RESTRICTION NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

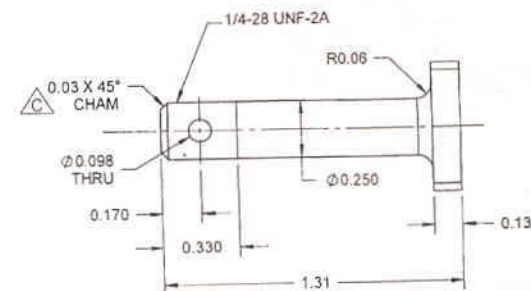
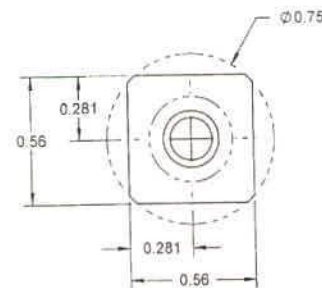




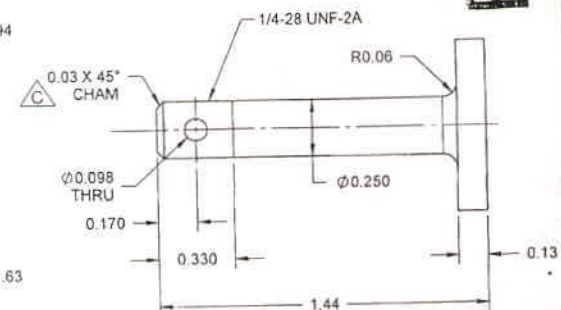
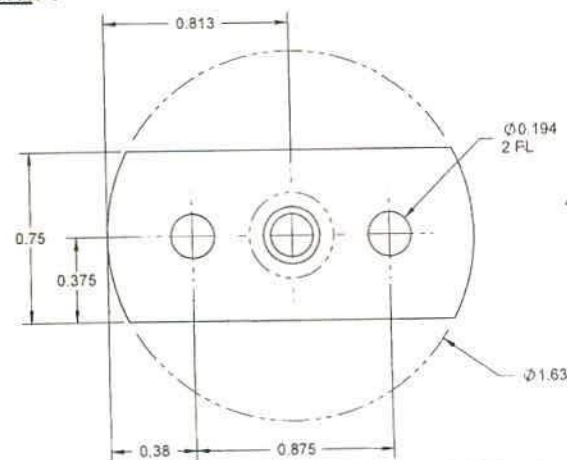
D3953-1 GAS SPRING BRACKET
(FULL LID)



SECTION A-A C7-2



D3953-3 GAS SPRING STUD, LID



D3953-5 GAS SPRING STUD, BASE

NOTES:

NOTES:
1) MATERIAL - 1: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA

-3 & -5: AISI 304 STAINLESS STEEL BAR
REF DART SPEC M304B
OR:
AIS1 304/316 STAINLESS STEEL ROD
REF DART SPEC M304R

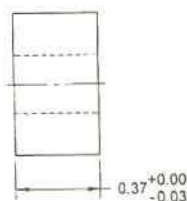
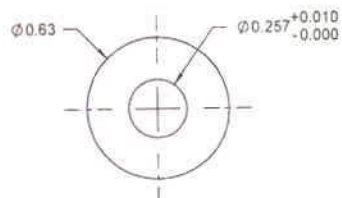
- 2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3953-X" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT -1: 0.11 lbs
 -3: 0.03 lbs
 -5: 0.06 lbs

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3953	SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR	<i>[Signature]</i>	GAS SPRING LID COMPONENTS	NTS
DATE	10.01.29	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD. <small>THIS DOCUMENT IS UNCLASSIFIED AND NOT BE RELEASED OR DISSEMINATED TO THE PUBLIC OR TO ANY OTHER PERSON OR ENTITY <small>EXCEPT TO THE EXTENT THAT ANY PORTIONS ARE COVERED BY COMPARATIVE TO THE ANY OTHER RELEVANT PART OF IT</small> </small> </small>	

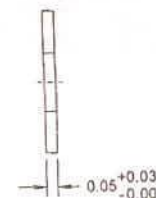
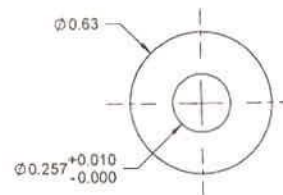
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2010-02-26



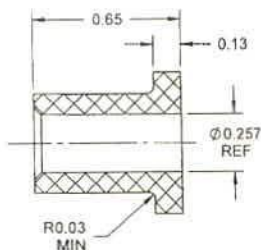
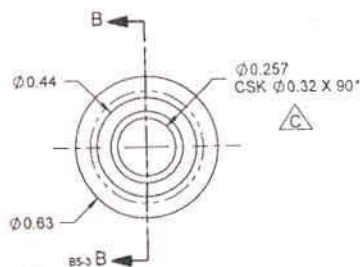
74703



D3953-7 GAS SPRING SPACER

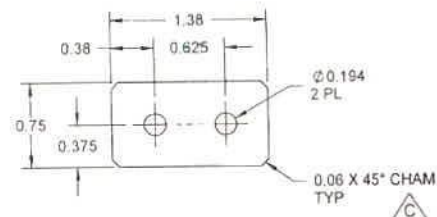


D3953-9 GAS SPRING WASHER



SECTION B-B 07-3

D3953-11 GAS SPRING SPACER



D3953-13 GAS SPRING SPACER

NOTES:

1) MATERIAL -7,-9 & -11: DELRIN II 150E OR ACETRON GP ACETAL, BLACK
REF DART SPEC M-DELRIN-R

-13: AISI 304 STAINLESS STEEL BAR
REF DART SPEC M304B

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION -13 ONLY. IDENTIFY WITH DART P/N "D3953-13" USING FINE POINT PERMANENT INK MARKER

7) WEIGHT -7/-9/-11: < 0.01 lbs EACH

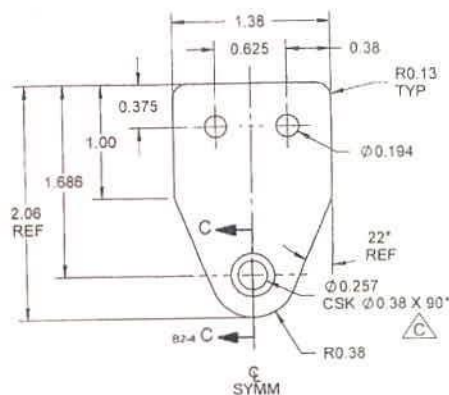
-13: 0.17 lbs

RELEASED
2010-02-26

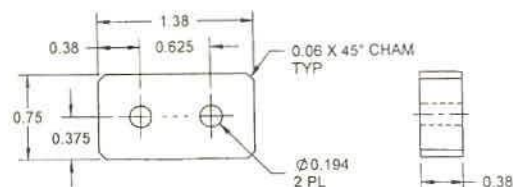
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MFG APPR.	<i>[Signature]</i>	D3953	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR	<i>[Signature]</i>	GAS SPRING LID COMPONENTS	
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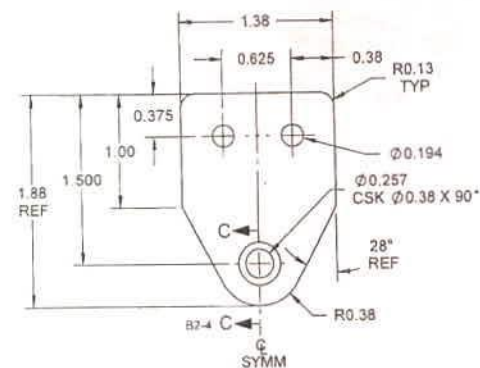
74703



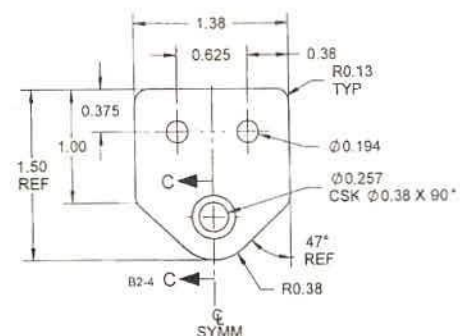
D3953-15 GAS SPRING BRACKET
(SPLIT LID)



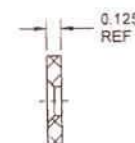
D3953-17 GAS SPRING SPACER
(SPLIT LID)



D3953-19 GAS SPRING BRACKET
(SQUARE BASKET)



D3953-21 GAS SPRING BRACKET
(SQUARE BASKET)



SECTION C-C

RELEASED
2010-02-26

- NOTES:**
- 1) MATERIAL -15/-19/-21: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S11GA
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3953-X" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT -15: 0.08 lbs
-17: 0.10 lbs
-19: 0.07 lbs
-21: 0.06 lbs

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. C
MFG APPR	JP	D3953	SHEET 4 OF 4
APPROVED	JP	TITLE	SCALE
DE APPR	JP	GAS SPRING LID COMPONENTS	
DATE	10.01.29	NTS	
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